

Work Order ID 48146

Friday, June 26, 2009 10:45:08 AM



Page 1

Item ID: D3117-3

Revision ID: C

Item Name: Seal Filler

Start Date: 7/15/2009 Start Qty: 500.00

Accept



Setup Start



Stop



Required Date: 8/3/2009 Req'd Qty: 500.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *W*

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3117	Rev C

100



PURCHASING

Purchasing

Memo 0.00

Purchasing

Issue P/O: *8643* D3117-3 Seal as per Dwg D3117 Possible Supplier:
VIP RubberReplace Premier P/N: B45-43000-03
Material release note required

110



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo 0.00

Packaging

Ensure Material Release Note is attached

120



QC6- Inspect dimensions to drawing

QC

Memo 0.00

Quality Control

Check dims to dwg and certification attached

*See other w/o**✓**R-9/7/15* *SVJ**⇒ 50147/15**(KSDST)**✓*

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Item ID: D3117-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: Seal Filler

Start Date: 7/15/2009 Start Qty: 500.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 500.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
DescriptionIdentify as per dwg & Stock Location: UOPSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

9/7/16

500ffsp

Packaging

Packaging

Memo

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

09/07/2009



Memo

0.00

U 507.17

Picklist Print

Page 1

Friday, June 26, 2009 10:45:08 AM

Work Order ID: 48146



Parent Item: D3117-3RevC



Parent Item Name: Seal Filler

Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 500.00

Required Qty: 500.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3117-3PRevC		Purchased		No		110	f	0.0000	500.0000			✓

Seal Filler

Date: Friday, 22/05/2009 2:26:36 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SEAL		
Job Number	: 48146			Part Number	: D31173		
Estimate Number	: 10736			Drawing Number	: D3117 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 22/05/2009	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: PURCHASED PARTS	Due Date	: 17/06/2009		
Previous Run	: 47475			Qty:	500	Um:	Each
Written By	<i>G</i>						
Checked & Approved By	<i>CLO9/05/22</i>						
Comment	: Est. A 03.01.22 New issue KJ/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: <i>8843</i>	<i>CLO9/05/22</i>
		D3117-3 Seal as per Dwg D3117	
		Possible Supplier: VIP RubberReplace Premier P/N: B45-43000-03	<i>(500)</i>
		Material release note required	
2.0	D31173P	Seal Filler	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 500.0000 Each(s) SEAL FILLER	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached	<i>✓</i>
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	<i>SOLUT/500 PT</i>
		Inspect Level 6 Check dims to dwg and certification attached.	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	<i>✓</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 2:26:36 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAL

Job Number: 48146

Part Number: D31173

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

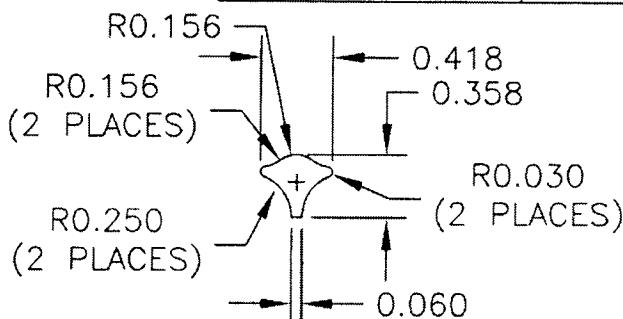
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3117
		REV. C
DATE 05.10.03		SHEET 1 OF 1
		TITLE SEAL
		SCALE 1:1

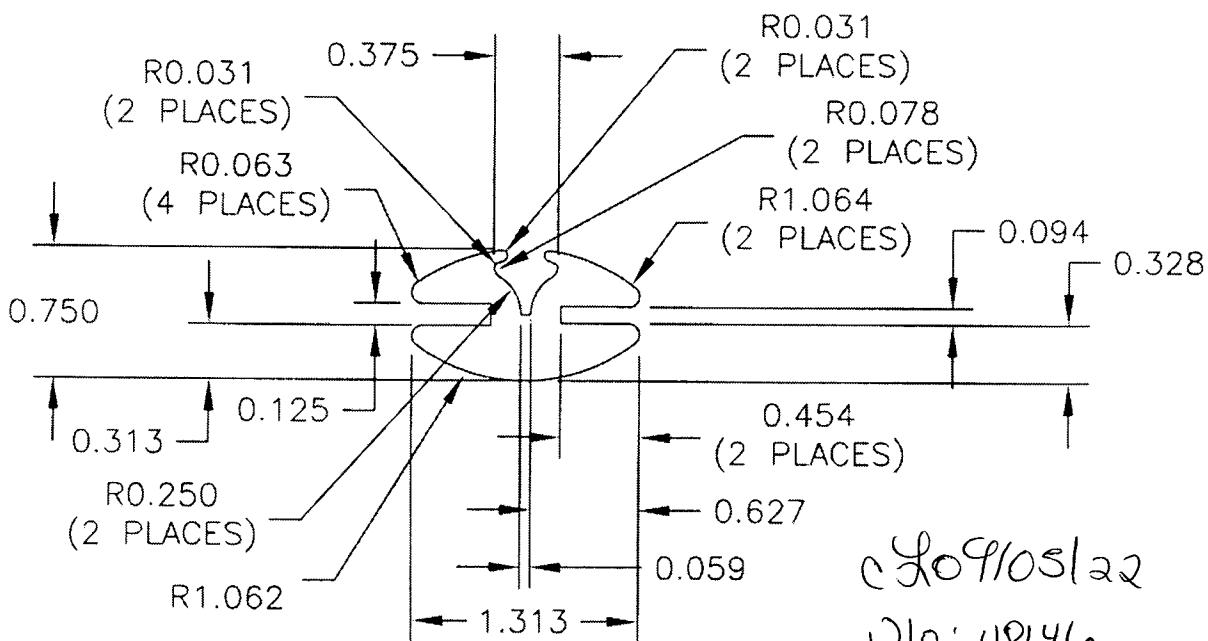
A	02.04.15	NEW ISSUE
B	04.10.18	UPDATES NOTES
C	05.10.03	50 DUROMETER WAS 60 DUROMETER



RELEASED

05.10.03 *[Signature]***D3117-3-XXXX SEAL FILLER**

REPLACES PREMIER P/N B45-43000-03

**D3117-1-XXXX SEAL RETAINER**

REPLACES PREMIER P/N B45-43000-01

NOTES

- 1) -XXXX = LENGTH IN INCHES (EG. 10" LONG = -0100, 87.5" LONG = -0875)
- 2) MATERIAL: BLACK RUBBER 50 DUROMETER (HARDNESS) NEOPRENE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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Vip Rubber Company

EXTRUDED AND MOLDED RUBBER • EXTRUDED PLASTIC
540 S. CYPRESS STREET, LA HABRA, CA 90631
(310) 905-3458 • (800) 722-4VIP
Fax: (310) 905-3460

Order

UART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY ONTARIO, CANADA
K6A1K7 613-632-9577

3626

CERTIFICATION OF COMPLIANCE

SHIPPER NO.

80646

THIS IS TO CERTIFY THAT
THE MATERIAL FURNISHED
ON THIS PURCHASE ORDER
WAS MADE IN STRICT
CONFORMANCE WITH THE
NOTED SPECIFICATION.

PART NO./DESCRIPTION	QUANTITY ORDERED
P/N D3117-1 REV C RETAINER	500 FT
P/N D3117-3 REV C FILLER	500 FT
(DWG. #D3117 REV C)	

CURE DATE

3-12-09

SPECIFICATION

50/NEOPRENE FORMULATED TO MEET THE FLAME
RESISTANCE TEST OF FAR 25.853a LOT #

193559

By

Martin Perez

MARTIN PEREZ
TECHNICAL DIRECTOR

VIP RUBBER COMPANY

SO 09/09/09

DATE SHIPPED *7/9/09*

QTY. SHIPPED *500 FT*

500 FT

500 FT



VIP Rubber Company, Inc.

540 S. Cypress
La Habra, Ca. 90631**FINAL INSPECTION REPORT**

Customer	Dart Aerospace Ltd.			Purchase Order #	P000008843		
Part Number/Dwg. Number	D3117-1 &-3 (Filler & Retainer)			Revision	C		
Job #	1299	Lot #	193141	AQL	Rubber 4.0 / C=0; Plastic 6.5 / C=0		
Lot Size	J100 PT	J100 FT		Sample Size			
Dimensions Measured							
Dim.	.418		.750				
Tol.+/-	.051		.063				
Range	0.469		0.813				
	0.367		0.687				
Descr.	Filler		Retainer				
1	.418		.800				
2	.418		.800				
3	.420		.800				
4	.420		.805				
5	.418		.800				
6	.418		.800				
7	.420		.805				
8	.420		.800				
9	.418		.800				
10							
11							
12							
13							
14							
15							
16							
17							
18							
19							
20							
Other Observations (If Required)							
	Required	Tolerance	Actual		Required	Tolerance	Actual
Durometer	50	+/- 5	50	Visual	✓	N/A	ace
Color	Black	N/A	ace	Marking	N/A	N/A	
Inspection Notes:							
No. of Observations	12	Qty. Approved	12	Qty. Rejected	0		
Inspected By	J.O.			Date	7/9/09		